

Work Order ID 125500

Thursday, October 09, 2014 1:26:32 PM

125500

Page 1

Item ID: D3282-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Web (206L/407)
 Start Date: 10/9/2014 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 10/9/2014 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-10-09 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3282	D

100
100
 Skidtubes
 Skidtubes
 Skidtubes
 Memo
 1-Cut to length as per Dwg D3282.
 2- inspect for surface damage as per QSI0018
 3- Deburr

110
110
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 1-Machine as per Folio FA579 & Dwg D3282
 2-Deburr

120
120
 QC
 Quality Control
 Memo

10 14-10-14 DGC
 10 14-11-26
 20 9-89
 44 14/11/27 9-89
 10 14-11-26
 20 9-89

150 151 152

2025

Work Order ID 125500

Thursday, October 09, 2014 1:26:32 PM

125500

Page 2

Item ID: D3282-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Web (206L/407)

Start Date: 10/9/2014 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/9/2014 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							DAS 08 9-89
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
03
9-89

14-12-8

Work Order.ID 125500

Thursday, October 09, 2014 1:26:32 PM

125500

Page 3

Item ID: D3282-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Float Web (206L/407)

Start Date: 10/9/2014 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/9/2014 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

Skidtubes

Skidtubes

0.00

Memo

0.00

Skidtubes

1-Install doublers as per Dwg D3282.

10

0

14-12-09

DGL

DAS
16
9-09

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10

0

14-12-09

180

180

Packaging

Packaging

Identify as per dwg & Stock Location: L6002 0.00

0.00

Memo

0.00

10

0

14-12-09

DGL

11-11-11

11-11-11

Work Order ID 125500

Thursday, October 09, 2014 1:26:32 PM

125500

Page 4

Item ID: D3282-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Web (206L/407)

Start Date: 10/9/2014 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/9/2014 Req'd Qty: 10.00

10

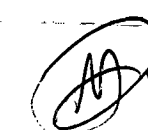
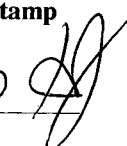
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

14/12/10  14-12-09

Picklist Print

Thursday, October 09, 2014 1:26:36 PM

Page 1

Work Order ID: 125500

125500

Parent Item: D3282-041

D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 10/9/2014

Required Date: 10/9/2014

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B05.09.23Procedure changeKJ/JLM
remove LPS as per dwg revD DD verf:JLM IPP REV:C 11.09.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2792-130		Manufactured	No			100	Each	55.0000	1	10			

D2792-130

EXTRUSION

**

Location Loc Qty Loc Code

HALL

55

112219

55

10

14-10-14

D3283-1

Manufactured No

160

Each

47.0000

2

20

D3283-1

Doubler

**

Location Loc Qty Loc Code

LG

40

119564

40

ST256

7

92179

7

13

DGL 14-12-8

MS20470AD4-7

Purchased No

160

Each

3,096.000

57

570

MS20470AD4-7

Rivet, Universal Head

**

Location Loc Qty Loc Code

ST312

3096

123525

1257

124231

539

m128228

1300

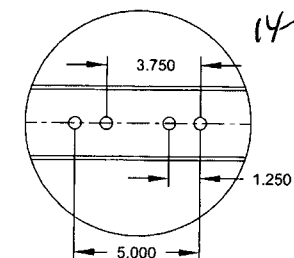
20

559

DGL 14-12-8

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 126500 MJS

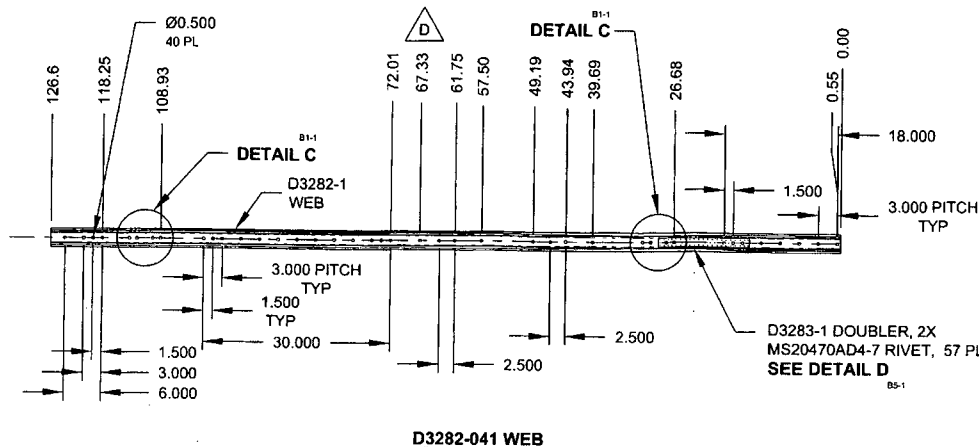
14/10-09



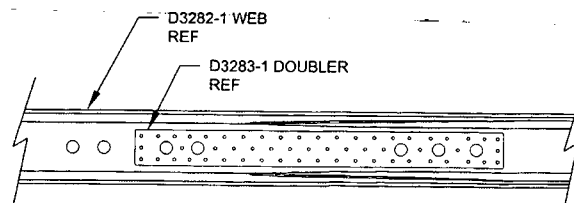
DETAIL C
D5-1
D6-1

NOTE: RIVET HOLES/DOUBLER
NOT SHOWN FOR CLARITY

RELEASED
2011-09-12



D3282-041 WEB



DETAIL D
C4-1

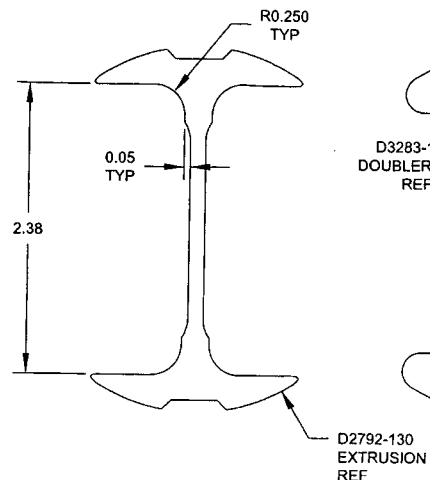
NOTES:

- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 20.0 lbs
- 8) SEE PAGE 2 FOR MACHINING DETAILS

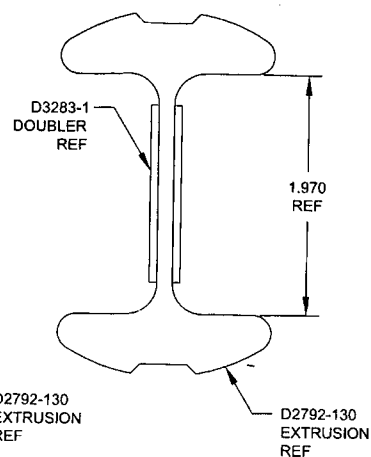
D	ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3282	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

SECTION A-A

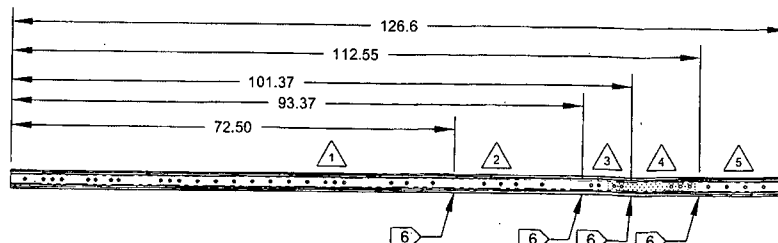


SECTION B-B



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12
MD

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3282	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	125500
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.600	✓		SLO1	Tape
1.500	+/-0.010	1.500	✓			
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	6.000	✓			
1.250	+/-0.010	1.250	✓			
30.000	+/-0.010	30.000	✓			
1.500	+/-0.010	1.500	✓			
72.01	+/-0.030	72.010	✓			
61.75	+/-0.030	61.750	✓			
57.50	+/-0.030	57.500	✓			
49.19	+/-0.030	49.190	✓			
43.94	+/-0.030	43.940	✓			
39.69	+/-0.030	39.690	✓			
26.68	+/-0.030	26.680	✓			
0.55	+/-0.030	.553	✓		SLO8	Vern
1.970	+/-0.010	1.970	✓			
2.38	+/-0.030	2.380	✓			
0.05	+/-0.030	.058	✓		SLO8	Vern

Measured by: 20 9-89		Audited by: 13 DAS	Preliminary Approval:
Date: 14-11-26		Date: 14/12/04 08 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	

